Work Orde <i>May-28-13 10:1</i>		45		*102	445*						Page 1
Itém ID: Revision ID: Item Name:	D3198-1 Fitting 6/03/13 S	tart Qty: 12.00 Req'd Qty: 12.00	*12* *12*	Accept	*N900 Cust Item Customer	ID:	100)*	Setup Star	1.7	S1* S2*
Reference: Approvals:		MLS		Tooling: SPC (Y/N):		Date:		I	Run Stai Sto	P	R1* R2*
Sequence ID/ Work Center IE		peration escription		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revisio										
D3198	Rev A	1									
*100 *100* Waterjet FLOW CNC Waterje		OW WATER JET Memo 1-Cut as per Deburr if nec		0.00 0.00 AProg Rev:/	2-			24	_&_	17 - 6	;-27
*110 *110*	Qı	C2- Inspect parts off ma	nchine FAI/FAIB	0.00				24		/3	-6-27
Quality Control											
120 *120* QC	Q	C8- Inspect parts - seco	nd check	0.00				Q	G (F	06.93	0As 09.

Memo

Quality Control

DQA:			Date:										
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:		_					Wor	rk Order up	date only	
Work Orde	er:					DISPOSITION			AGAINST	DEP.	ARTMENT	PROCESS	
	-					Rework			Skid-tube Crosstube			Water Jet	Engineering
Part N	No.					Scrap			Machining Small Fab		Prod	d. Eng. Coor.	Quality
	_					Use-as-is		Therr	moforming Finishing			e/Packaging	Other
NCR I	۷o					Suspected Unapproved			Large Fab Composite			Supplier	
D t					0						1		
Root Cause		Date	Ston	Otre	Desci	ription of work order update		Initial	Action		Sign &		
Design	\sqcap	Date	Step	Qty		or non-conformance	Cn	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data	\vdash												
Equip/Tooling	H												
Handling/Pre	H												
Material	П												
Operator	П				-								Ì
Offset/Setup	П												
Process	П								·				
Supplier													
Training													
Transport													
Unapproved													
							FAI	ULT CA	TEGORY				
Landi	ng G	ear		,		General		_					
	Ц١	Bending			<u> </u>	Bend		Folio/F	Program		Outside Dimi	ensions	Pressure/Forced
	\vdash		ot Concer	ntric	_	BOM/Route		Grain			Over/Under	tolerance	Set-up
	\vdash	Cracks				Broken/Damage/Defect		Hardwa	are	∐F	art Incorrec	t	Temperature/Cure
	-		nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified	∐ F	Part Lost/Mis	ssing	Weld
	\vdash	Cuffs				Contamination		1	tions Incomplete/Unclear	∐ F	art Moved	L	Wrong Stock Pulled
	_	Crushing			_	Countersink		1 ~	gned/off center	LJ₽	ositioned W	/rong	_
ŧ	\vdash	Heat Trea			<u> </u>	Cut Too Short		Mislabe		F	ower Loss/S	Surge	Other
	_		n Strip in	Tube	<u> </u>	Drawing		Misread		_		<u> </u>	
	-	Marks/Ch			<u> </u>	Drill Holes	_	Off-set		_			
	—	Turning S			<u> </u>	Finish		i	Calibration	_			
	\bigsqcup \setminus	Wave/Tw	ist in Tub	e		Fit/Function		Out of 9	Sequence				

1.											
Work Orde May-28-13 10:1	er ID 10			*102	2445*		· · · · ·				Page 2
Revision ID:	D3198-1 Fitting			Accept	*N900	040	100)* ፡	Setup Star	נימו	1* 2*
Start Date: Required Date: Reference:	6/03/13 6/03/13	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust Item I Customer:	I D:					
Approvals:	Process Pl	lan:	Date:	Tooling:	D	ate:		I	Run Star Sto _l	"NR	1*
	QC:		Date:	SPC (Y/N):	D:	ate:			300	*NR	2*
Sequence ID/ Work Center II 130 *120* Brake NC Brake NC)	Operation Description NC BRAKE Memo 1-Deburr if r	necessary 2-Form as per I	Set Up/ Run Hours 0.00 0.00 Owg D3198	Tool ID	Tool#	Plan Code	Accept Qty 24	Reject Qty		sp. amp /3l/
140 *140* QC Quality Control		QC5- Inspect part comple Memo	eteness to step on W/O	0.00 AS 16	310/02		(d	who was)		

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

150
Powder Coating

Memo
START TIME:

FINISH TIME:

OVEN TEMPERATURE:

12/10

24XJ mf 13/57/03

3200F

molosa

DQA:			Date:										Talac
QA Closed:			Date:			WORK ORDER NON	-C(ONFO	RMANCE / UPDATE	w	ork Order up	ndate only	AEROSPACE
	_					DISPOSITION	-		AGAIN		PARTMENT		
Work Orde	er:						٦			٠	1	·	
Part N	No.					Rework Scrap	1		Skid-tube Crosstu Machining Small F		Pro	Water Jet d. Eng. Coor.	Engineering Quality
				· · · · · · ·	_	Use-as-is	1	1	noforming Finishi		4	re/Packaging	Other
NCR N	No					Suspected Unapproved]		Large Fab Compos			Supplier	
Root					Desci	ription of work order update	Ti	Initial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
Design													
Doc/Data			;		-			•					
Equip/Tooling	Ш												
Handling/Pre												-	
Material		,											
Operator													
Offset/Setup													
Process											·		
Supplier	Ш						İ						
Training													
Transport		·											
Unapproved							<u> </u>						
							FA	ULT CA	TEGORY				-
Landi	ng Gea				_	General					_		
	_	nding				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
	☐ Ce	ntre No	t Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	_	acks				Broken/Damage/Defect		Hardwa	ire		Part Incorred	ct	Temperature/Cure
			k/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified	L	Part Lost/Mi	ssing	Weld
	Cu					Contamination		Instruct	ions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
	_	ushing				Countersink		Misalig	ned/off center		Positioned V	Vrong	
	_	at Treat			Щ	Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
	—		Strip in	Tube		Drawing		Misread	d				
	\vdash	arks/Ch				Drill Holes		Off-set					
	Tu	rning Se	quence			Finish		Out of (Calibration				
	l lwa	ave/Twi	st in Tub	le		Fit/Function		Out of	Cognonco				

W	ork	Ord	ler l	D	102445

Work Ord <i>'May-28-13 10:</i>		02445		*102	2445*							Page 3
Item ID: Revision ID: Item Name:	D3198-1 Fitting			Accept	*N900	040	100)* ^s	Setup	Start Stop	*N:	S1*
Start Date: Required Date Reference:	6/03/13	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust Item I Customer:	D:				٠.	IV.	
Approvals:	Process P QC:	lan:	Date:	Tooling: SPC (Y/N):		ate:		I	Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center 1 160 *160* QC	ID	Operation Description QC3- Inspect Part Finish Memo		Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Quality Control		Identify as per dwg & Sto		0.00					//			
170 Packaging Packaging		Memo	59246A	0.00				/	1 <u>2</u>	-13 ₁	//	9 (2) 1/1
1 RO QC Quality Control		QC21- Final Inspection - Memo	Work Order Release	0.00					/:	214 _/	14 H ————————————————————————————————————	WF .
•											ſ	7MF 3-7-4

DQA:			Date:											1	A DT
0.0			. .			WORK ORDER NON	-C	ONFO	RMANCE / L	JPDATE			_		AEROSPACE
QA Closed:			Date:			<u> </u>		;			W	ork Order up	odate only	\Box	
Work Orde	er:					DISPOSITION				AGAINST	DE	PARTMENT,	/PROCESS		
						Rework	1		Skid-tube	Crosstube]	Water Jet	\neg	Engineering
Part N	No.					Scrap	1		Machining	Small Fab	\vdash	Pro	d. Eng. Coor.	\dashv	Quality
	_					Use-as-is	1		noforming	Finishing		1	re/Packaging	\exists	Other
NCR 1	No					Suspected Unapproved]		Large Fab	Composite			Supplier		
Doot	<u> </u>		<u> </u>		D		_		1						
Root	ļ	Data	Chan		Desci	ription of work order update		Initial	1	ction		Sign &			
Cause Design	\vdash	Date	Step	Qty		or non-conformance	Cr	nief Eng	Desc	ription		Date	Verification		QC Inspector
Doc/Data	Н								:					ļ	
Equip/Tooling	H														
Handling/Pre	\vdash														
Material	H														
Operator	Н														
Offset/Setup															
Process						•									
Supplier	П														
Training															
Transport															
Unapproved															
							FA	ULT CAT	TEGORY			<u> </u>			
Landi	ng Ge	ear				General		_							
	L B	ending				Bend		Folio/P	rogram			Outside Dim	ensions	\neg _P	ressure/Forced
		entre No	ot Concer	ntric		BOM/Route		Grain				Over/Under	tolerance	S	et-up
	\vdash	racks				Broken/Damage/Defect		Hardwa	re			Part Incorred	et [T	emperature/Cure
	_		ık/Ripple,	/Wave		Burrs	L	Inspecti	ion Incomplete/U	nqualified		Part Lost/Mi	ssing	v	Veld
	-	uffs				Contamination	L	•	ions Incomplete/			Part Moved		v	Vrong Stock Pulled
	_	rushing				Countersink	L	i	ned/off center			Positioned W	/rong		
		leat Trea				Cut Too Short	Η-	Mislabe				Power Loss/S	Surge	<u> </u> c	Other
	-		n Strip in	Tube		Drawing		Misread	d				-		· ·
	_	/larks/Ch				Drill Holes	_	Off-set							
	—	_	equence		\vdash	Finish	<u> </u>	ł	Calibration						··········
	ιIV	vave/Tw	ist in Tub	e	1	Fit/Function		I Out of S	Cognopeo						

Picklist Print

May-28-13 10:11:59 AM

Work Order ID:

102445

Parent Item:

D3198-1

Parent Item Name:

Fitting

Start Date: 6/03/13

Required Date: 6/03/13

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP: A03.11.11New IssueKJ/RF

IPP Rev:B Now on Waterjet 07-01-09 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq 1D	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	157.2333	0.105	1,3263156	 5		***************************************
304/316 0.125 Sheet										<u> </u>	3.6-0	37	

1.6

DQA:		Date:										7	TRAGG
QA Closed:		Date:			WORK ORDER NON-	-C(ONFO	RMANCE / UPDATE	W	ork Order up	odate only		AEROSPACE
Work Orde					DISPOSITION			AGAINST		PARTMENT	•		
WOLK OLD	=1.			- 1	Rework			Skid-tube Crosstube]	Water Jet	\neg	Engineering
Part N	lo.			1	Scrap			Machining Small Fab	_	Pro	d. Eng. Coor.		Engineering Quality
				-	Use-as-is			noforming Finishing	\vdash	•	re/Packaging		Other
NCR N	No			_	Suspected Unapproved			Large Fab Composite	-]	Supplier		
Root			· T	Descr	ription of work order update		Initial	Action		Sign &			
Cause	Date	Step	Qty	0 000.	or non-conformance		nief Eng			Date	Verification	,	QC Inspector
Design		1 1 1 1						Везоприон		Dute	Vermeation		QC mapeetor
Doc/Data													
Equip/Tooling								:					
Handling/Pre													
Material												İ	
Operator													
Offset/Setup													
Process												1	
Supplier											:	l	
Training			1										
Transport													
Unapproved												- 1	
						FAI	ULT CA	TEGORY		***************************************		•	
Landi	ng Gear	_			General								
	Bendir	g			Bend		Folio/F	Program		Outside Dim	ensions		Pressure/Forced
	Centre	Not Conce	ntric		BOM/Route		Grain			Over/Under	tolerance		Set-up
	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	ct		Temperature/Cure
	Crimp/	Kink/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing		Weld
	Cuffs				Contamination		Instruct	tions Incomplete/Unclear		Part Moved			Wrong Stock Pulled
	Crushi	ng			Countersink]Misalig	gned/off center		Positioned V	Vrong '		
	Heat T	reat			Cut Too Short		Mislabe	eled		Power Loss/	Surge		Other
	Inspec	tion Strip in	Tube		Drawing		Misrea	d			• • • • • • • • • • • • • • • • • • •		
	Marks	/Chatter			Drill Holes		Off-set						
	Turnin	g Sequence	!		Finish		Out of	Calibration					
	Wave/	Twist in Tul	be		Fit/Function		Out of	Sequence					

DART AEROSPACE LTD	Work Order: 102445
Description: Fitting	Part Number: D3198-1
Inspection Dwg: D3198 Rev: A	Page 1 of 1

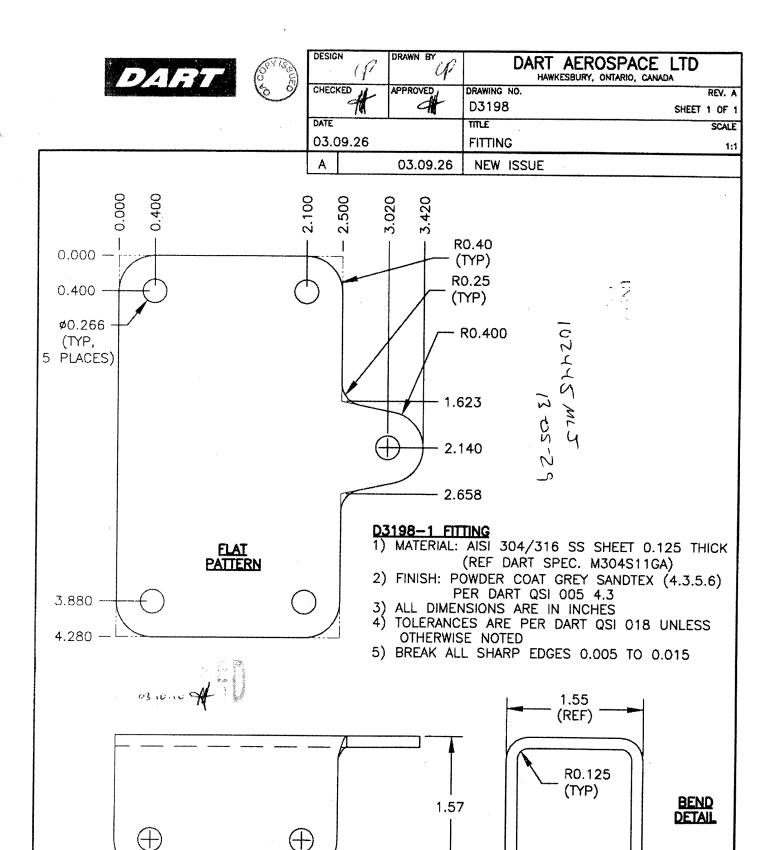
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

·	<u> </u>				<u> </u>
Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
+0.006/-0.001	0.268			JK MOI	
+/-0.010	4.284	1		3,,	
+/-0.010	2.510	/			
+/-0.010	3.421	1			
+/-0.010					
+/-0.010		/			
+/-0.010		~			
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				·····	
	+0.006/-0.001 +/-0.010 +/-0.010 +/-0.010 +/-0.010 +/-0.010 +/-0.010	Tolerance Dimension +0.006/-0.001	Tolerance Dimension Accept +0.006/-0.001	Tolerance Dimension Accept Reject +0.006/-0.001	Tolerance Dimension Accept Reject Inspection +0.006/-0.001

Measured by:	A	Audited by:	(09)	Prototype Approval:	N/A
Date:	13-6-27	Date:	13-06-25	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.03.13	New Issue	KJ/JLM .	
В	08.05.28	Ø0.266 was Ø0.270	KJ/DD	13



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